

CLAIMS

1. A process for the manufacture of a single or multi-compartment, rigid, water-soluble container, containing a detergent composition, wherein the container is at least partially formed of injection moulded water soluble polymer; the process comprising the steps of forming the container, filling with the detergent composition and sealing, wherein the container is allowed to contact / brought into contact with a plasticiser after sealing.
2. A process according to claim 1, wherein the plasticiser is water.
3. A process for the manufacture of a single or multi-compartment, rigid, water-soluble container, containing a detergent composition, wherein the container is at least partially formed of injection moulded water soluble polymer; the process comprising the steps of forming the container, keeping the container under substantially anhydrous conditions, filling with the detergent composition and sealing, wherein the container is allowed to contact / brought into contact with a plasticiser after sealing.
4. A process according to claim 3, wherein the container comprises a PVOH polymer or a derivative thereof.
5. A process according to claim 4, wherein the container comprises an additional injection moulded water-soluble polymer, which when dissolved in water is active in detergency.

6. A process according to claim 5, wherein the additional injection moulded water-soluble polymer is poly(vinylpyrrolidone), poly(acrylic acid) or an ester thereof or poly(maleic acid) or an ester thereof, or a copolymer of any thereof.

7. A process according to claim 4,5, or 6, wherein the first and additional polymer(s) are simultaneously or sequentially injection moulded.

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8. A process according to any one of the preceding claims wherein the container is made from a water-soluble receptacle part and is sealed by a water-soluble closure part, preferably in the form of a film or injection-moulded, rigid closure.

9. A process according to claim 8 wherein the closure part comprises a poly(vinyl alcohol) film or closure.

20 10. A process according to claim 8 or 9 wherein the receptacle part has side walls which terminate at their upper end in an outward flange, to which the closure part is sealingly secured.

25 11. A process according to claim 8 wherein the closure part comprises a plastic film.

12. A process according to any one of the preceding claims wherein the detergent composition comprises a powder, gel, paste or low water liquid formulation.

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13. A process according to any one of claims 10 to 12 wherein the container comprises a tablet formulated for delayed and/or sustained release of a material.
- 5 14. A process according to claim 8 wherein the receptacle part comprises an upstanding wall which separates compartments thereof.
- 10 15. A process according to any one of claims 8 to 14 wherein the closure part is a transparent or translucent material.
16. A process as claimed in any one of the claims 1 to 15, wherein the containers are joined together in an array arrangement, but are readily separable from each other for use.
17. A method of manufacture of an array as defined in claim 16, which method comprises: forming an array of receptacle parts, each receptacle part being connected to adjacent receptacle parts, but being separable from them by a snap or tear action; charging the receptacle parts with washing composition; and sealingly securing a sheet of a water-soluble polymer over the top of the array, to form the closure parts for all the receptacle parts of the array.
18. A process as claimed in any claim from 1 to 15, which comprises melting the polymer(s), injecting the molten polymer(s) into a mould, removing the rigid water soluble container from the mould and adding the fabric care, surface care, or dishwashing composition into the container.

19. A process according to claim 18 wherein a first polymer and an additional polymer(s) are simultaneously or sequentially injected into the mould.

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20. A process according to claim 19 wherein the first polymer and the additional polymer(s) are sequentially injected into the mould, in any order, by one of the following techniques, multi-component injection moulding or sandwich injection moulding.

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21. A process according to claim 20 wherein the first polymer and the additional polymer(s) are sequentially injected into the mould, in any order, injection moulding a polymer or molten polymer mix into a mould, removing the solid polymer and inserting into a second mould and injection moulding a second polymer or polymer mix into the second mould.

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22. A process according to claim 20 wherein the first polymer and the additional polymer(s) are sequentially injected into the mould, in any order, injection moulding a polymer or molten polymer mix into a part of a mould, injection moulding a second polymer or molten polymer mix into a further part of the mould.

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23. A process according to claim 20 wherein the first polymer and the additional polymer(s) are simultaneously injection moulded into the mould as a molten mix.

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24. A process for the manufacture of a single or multi-compartment rigid, water-soluble container, containing a detergent composition, comprising: -

- 5 (i) Forming an array of containers in an injection moulding process;
- (ii) Removing the array from the mould;
- (iii) Placing the array in a storage area, substantially free of moisture;
- (iv) Filling the array of containers with the detergent
10 composition;
- (v) Placing a closure on the array;
- (vi) Sealing the containers; and
- (vii) Separating the array into individual containers;